

Work Order ID 131821

Tuesday, April 21, 2015 2:06:03 PM

131821

Page 1

Item ID: D4271-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Fitting Assembly Fwd Beam
 Start Date: 4/20/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: CZ Date: 15/04/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4271	D

100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D4271 REAM HOLE AS PER DWG CUT RIVET AT 1.130" C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD								

2x _____ 15/04/23 ^{DAS} 36 9-89

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

(2) _____ APR 23 2015 ^{DAS} 38 9-89

120	Identify as per dwg & Stock Location <u>G.A</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

2x _____ 15/04/24 ^{DAS} 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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131821

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Revision ID:
Item Name: End Fitting Assembly Fwd Beam Stop ***NS2***
Start Date: 4/20/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-27

MLJ 15-04-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

Picklist Print

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Page 1

Work Order ID: 131821

131821

Parent Item: D4271-025

D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.20 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4149-5 *D4149-5* Eyebolt Stud		Manufactured	No			100	Each	18.0000	1	1		15/04/23	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST103a				18					
				122937				4					
				129781				2					
				130604				12					
D4419-1 *D4419-1* Fwd Support Plate		Manufactured	No			100	Each	11.0000	2	2		15/04/23	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST105				11					
				123027				11					
D4281-1 *D4281-1* Spacer		Manufactured	No			100	Each	7.0000	1	1		15/04/23	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST097				7					
				117102				7					
D4281-3 *D4281-3* Spacer		Manufactured	No			100	Each	9.0000	1	1		15/04/23	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST097				9					
				123097				9					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Parent Item: D4271-025

D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

AN4C13A Purchased No
AN4C13A
BOLT

100 Each 46.0000 2 2

**

15/04/23 DAS 36 9-89

Location Loc Qty Loc Code

ST344 46
131677 38
m128818 8

MS20427M4-20 Purchased No
MS20427M4-20
RIVET

100 Each 98.0000 1 1

**

15/04/23 DAS 36 9-89

Location Loc Qty Loc Code

GA 98
118429 98

MS20615-4M18 Purchased No
MS20615-4M18
Rivet

100 Each 551.0000 10 10

**

15/04/23 DAS 36 9-89

Location Loc Qty Loc Code

CCK003 370
m123810 370
GA 74
m130358 74
ST307 107
125162 107

20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
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Parent Item: D4271-025

D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

100

Each

1,083.000

2

2

MS21043-4

Nut

15/04/23 DAS 36 9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

370

m128798

370

ST304

673

m128818

34

m131697

639

4

NAS1149C0432R

Purchased

No

100

Each

3,551.000

4

4

NAS1149C0432R

WASHER

15/04/23 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

2238

m125807

476

m131467

1762

ST271

1313

m131452

1313

8

DQA: _____ Date: _____



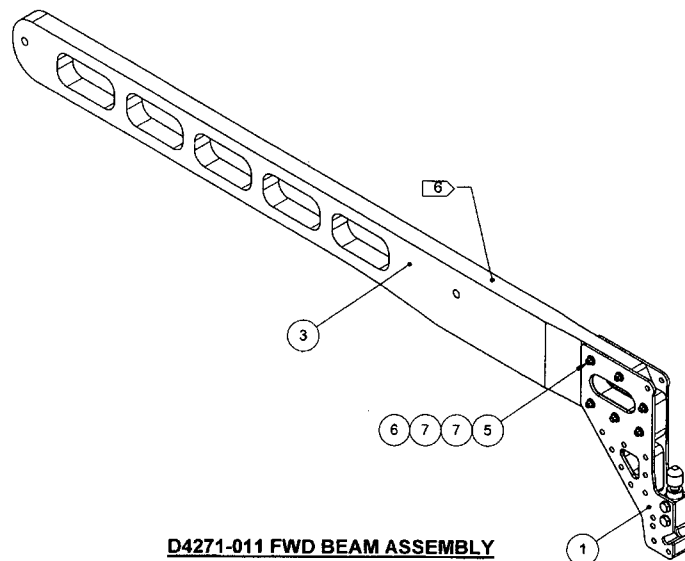
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

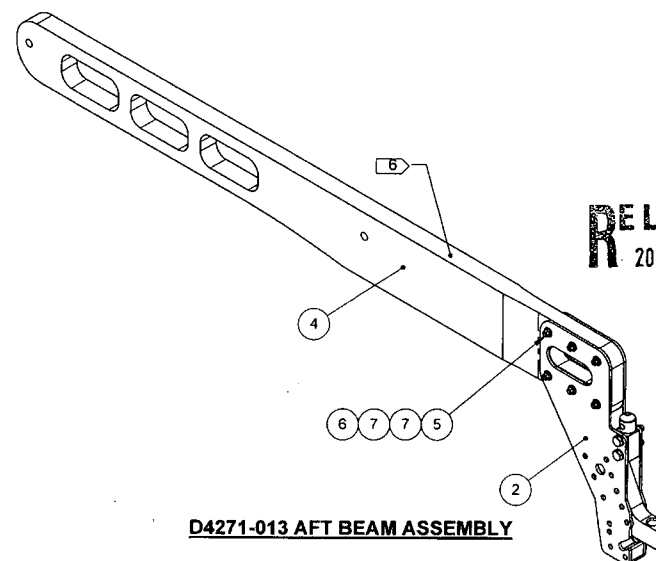
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

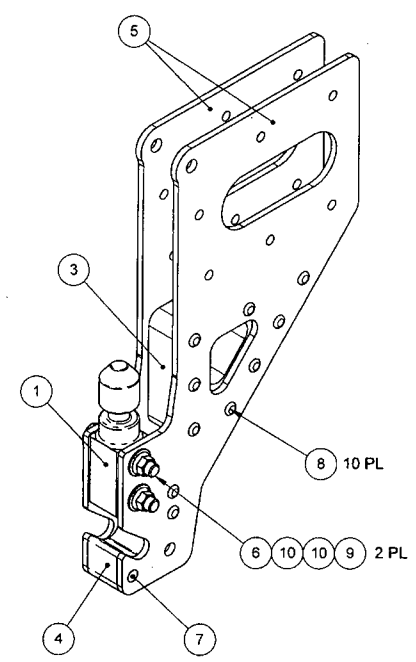
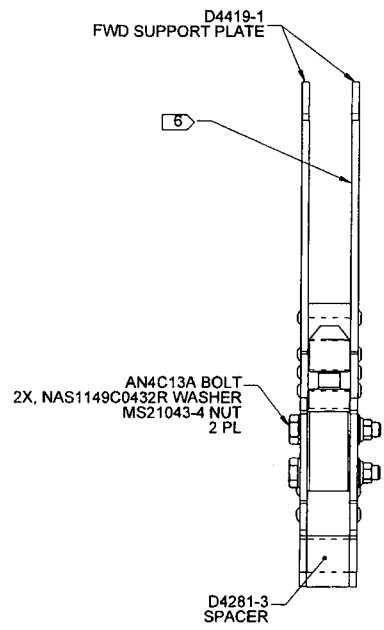
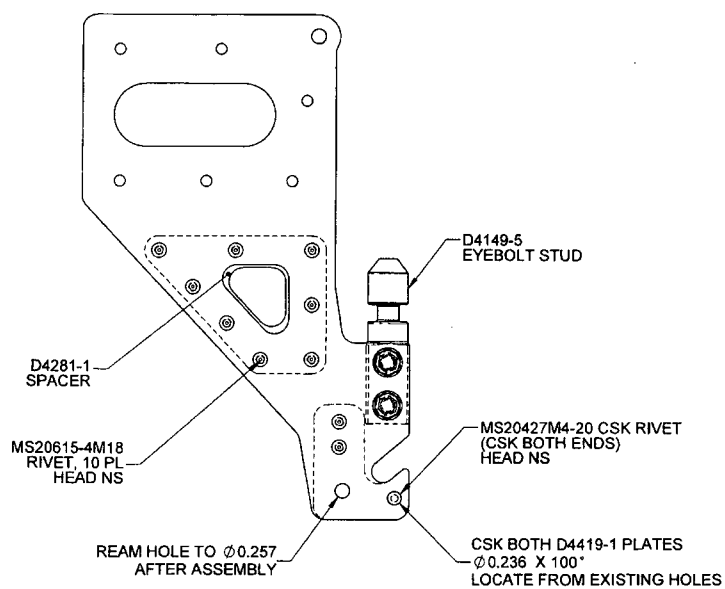
RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs
-013: 12.97 lbs

D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION.	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	E	D4271	SHEET 1 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM	QTY -025	P/N	DESCRIPTION
	X	D4271-025	FWD BEAM END FITTING ASSEMBLY
1	1	D4149-5	EYEBOLT STUD
3	1	D4281-1	SPACER
4	1	D4281-3	SPACER
5	2	D4419-1	FWD SUPPORT PLATE
6	2	AN4C13A	BOLT
7	1	MS20427M4-20	CSK RIVET (MONEL)
8	10	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER



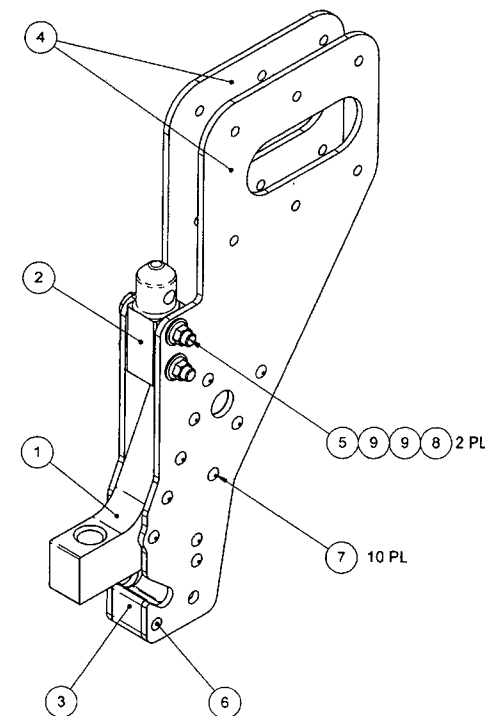
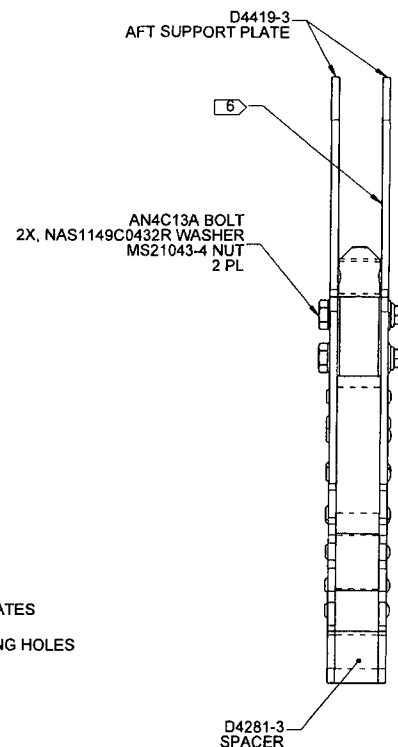
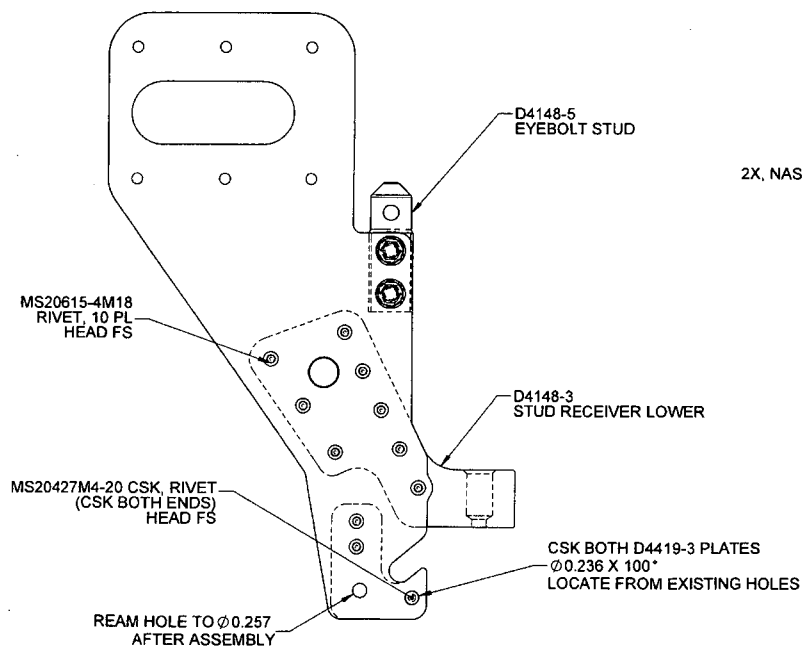
D4271-025 FWD BEAM END FITTING ASSEMBLY

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
 7) WEIGHT: 2.69 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4271	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES	
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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 2011-07-28

ITEM	QTY -027	P/N	DESCRIPTION
	X	D4271-027	AFT BEAM END FITTING ASSEMBLY
1	1	D4148-3	STUD RECEIVER LOWER
2	1	D4148-5	EYEBOLT STUD
3	1	D4281-3	SPACER
4	2	D4419-3	AFT SUPPORT PLATE
5	2	AN4C13A	BOLT
6	1	MS20427M4-20	CSK RIVET (MONEL)
7	10	MS20615-4M18	RIVET (MONEL)
8	2	MS21043-4	NUT
9	4	NAS1149C0432R	WASHER



RELEASED
2011-07-28

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
 7) WEIGHT: 4.25 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	BE	D4271	SHEET 3 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	#	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	